

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 412 GROSS WEIGHT TOWING KIT
Job Number	: 35318		
Estimate Number	: 12592		
P.O. Number	: N/A	Part Number	: D412666011
This Issue	: 10/22/2007 S.O. No. : N/A	Drawing Number	: D412-666 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 33583	Material	: N/A
Written By	: <u>LD 07.10.23</u>	Due Date	: 10/29/2007 Qty: 5 Um: Each
Checked & Approved By	: <u>LD 07.10.23</u>		
Comment	: Est Rev:B Added GHG 002 NG 02-03-06		
	: Est Rev:C As per Rev C JLM 07-09-07	Verified By:EC	

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0 DC DOCUMENT CONTROL



5

Comment: Photocopy bluefile & type labels per PPP412-666-011 CHG 004

K9 07.10.25

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
Pick Packing Kit

3.0 D2888 Lug



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

Lug

Batch:

4.0	AN615A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Batch:

50	AN645A	Bolt
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bolt

Batch:

M105350 12p

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 04/11/13
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 10/22/2007 4:00:21 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 412 GROSS WEIGHT TOWING KIT

Job Number: 35318

Part Number: D412666011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN960JD616

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 40.0000 Each(s)

Washer

Batch: M105125

7.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 20.0000 Each(s)

Nut

Batch: M104374

8.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-666-011

Location: E

PPP Rev: E

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



4 07-11-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

1.0 APPLICABILITY:

GROSS WEIGHT TOWING KIT D412-666-011 MAY BE INSTALLED ON DART D205-634-XXX OR D204-635-XXX OR D412-742-XXX SKIDTUBES INSTALLED ON 412 AIRCRAFT TO ALLOW GROUND HANDLING AT GROSS WEIGHT IN ACCORDANCE WITH BELL SERVICE INSTRUCTION BHT-412-SI-58. IT IS ALSO ACCEPTABLE TO INSTALL THIS KIT ON 204/205/210/212 AIRCRAFT EQUIPPED WITH DART SKIDTUBES IN ORDER TO PRESERVE THE LIFE OF THE AFT CROSSTUBES. THIS KIT CONTAINS ENOUGH PARTS TO INSTALL D2888 LUGS ON BOTH SKIDTUBES.

2.0 PARTS LIST:

QTY -011	PART	DESCRIPTION
X	D412-666-011	GROSS WEIGHT TOWING KIT
2	D2888	LUG
4	AN6-15A	BOLT
4	AN6-45A	BOLT
8	AN960JD616	WASHER
4	MS21042L6	NUT (or MS21042-6)

3.0 WEIGHT AND BALANCE:

INSTALLATION	WEIGHT	LONGITUDINAL	
		ARM	MOMENT
D412-666-011	1.90 lb 0.86 kg	163.0 in 4.14 m	310 in lb 3.56 m kg

4.0 PROCEDURE:

- 1) REMOVE AN6-12A BOLTS (4) ON INBOARD SIDE OF AFT SADDLE AND DISCARD. ON LANDING GEAR WITH DART AFT CROSSTUBES, REMOVE (4) AN6-40A BOLTS.
- 2) INSTALL D2888 LUGS WITH AN6-15A BOLTS (2) AS SHOWN IN FIGURE 1. USE AN6-45A (2) BOLTS ON DART CROSSTUBES, AS SHOWN IN FIGURE 2.
- 3) TORQUE BOLTS TO 95-110 in-lb (10.7-12.4 N-m).

5.0 NOTE:

IT IS ACCEPTABLE TO REPLACE THE AN6-15A/45A BOLTS WITH LONGER OR SHORTER AN6 BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960JD616 WASHERS UNDER NUT TO ENSURE 1.5 TO 4 THREADS IN SAFETY.

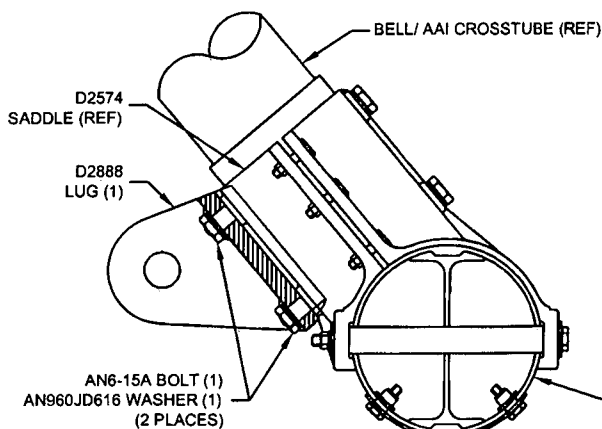


FIGURE 1
(BELL/AAI CROSSTUBES)

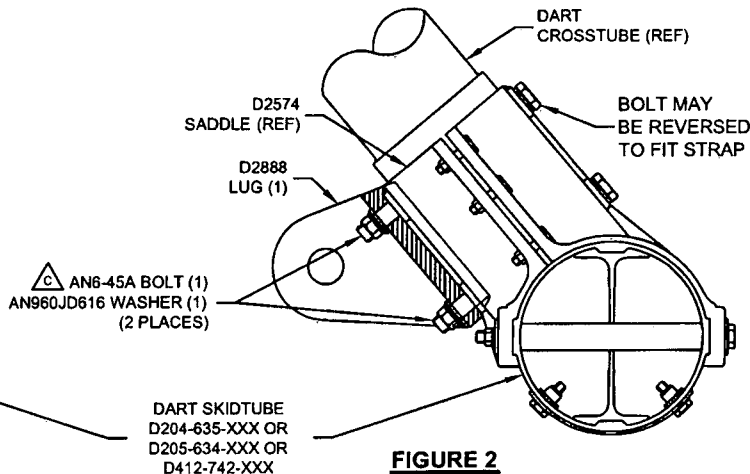


FIGURE 2
(DART CROSSTUBES)

C	- AN6-45A WAS AN6-43A, ADD NOTES - TO ENSURE COMPATIBILITY WITH D412-742-011/-013 - ESTIMATE (PARTS/PICK LIST) IS AFFECTED	MB	07.08.09
B	UPDATE KIT FOR BOTH SKIDTUBES AND COMPATIBILITY WITH DART CROSSTUBES	CP	02.03.04
A	NEW ISSUE	CP	99.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.	N/A	D412-666	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		412 GROSS WEIGHT TOWING KIT	1:4
DATE	07.08.10	COPYRIGHT © 1999 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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NO. 35318

